

**Amendments to the Specification:**

*Please amend the title as shown below:*

**SHEET METAL HEM ~~AND HEM FORMING PROCESS~~**

*Please amend numbered paragraph 6, as shown below:*

Recent developments in the field of hem forming have led to the development of reduced radius hems that improve the appearance of the fit of adjacent panels by reducing the perceived margin between adjacent panels. One example of such a hemming method is disclosed in U.S. Application Serial No. 10/063,757, now U.S. Patent 6,810,707, filed in the name of Samant et al., and assigned to Applicant's assignee. The Samant application describes a method of manufacturing a hem with a reduced radius hem. The method and apparatus discussed in the Samant application produces a hem with a radius sharper than half the total stack height of the inner and outer panels and can significantly improve the craftsmanship of closure panels.